

5/22

D3109-1 PTO

DART AEROSPACE LTD	Work Order:	23194
Description: Bracket	Part Number:	D3209-041
Dwg: D3209 Rev. A	Qty:	XX 12

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AS	05/05/09	4
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 , 1743-500P Batch: <u>H17037</u>	BSG	05/05/11	12
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1	BSG	05/05/12	12
4	QC2	Inspect parts as they come off the CNC machine	BSG	05/05/12	12
5	MV	Deburr and Tumble	BSG	05/05/12	12
6	QC8	Second check	EE	05.05.12	12
7	FP	Chemical conversion Coat as per QSI 005 4.1	MM	05.05.12	12
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Note: Cover the hole for D3209-1 before powder coat.	MM	05.05.12	12
9	QC3	Inspect Powder Coat	2	05.07.06	12
10	GA	Press fit bushing into the bracket as per Dwg D3209 Pick: Packing Kit Qty Part Number Description Batch 1 D3209-3 Bushing B3209	SD	05/07/12	12
		Identify as D3209-041	SAD	05/07/12	12
11	QC5	Inspect work to Step 10	2	05.07.13	12
12	ST	Identify and Stock	CD	05.07.13	12
13	AC	Cost / part: <u>37.75</u>	AB	05/07/15	11
14	DC	Close W/O <u>39.21</u> Inspect Level 21	HF	05/07/14	12

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	HF

RELEASED

HF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/12	3	Tab undersize (.180") Program error	<i>BB</i> 05/05/12	Destroy + Replace Folio has been changed.	BB 05/05/12	<i>BB</i> 05/05/12	<i>BB</i> 05/05/12	<i>BB</i> 05/05/12
05/07/13	3 11	wrong part # engraved onto parts. D3109-1 when should be D3209-1. program error, noticed after powder coat & bushing pressed in.	<i>BB</i> 05/07/13	Parts acceptable this time, and will be clearly identified in stock. Program error has already been changed . Identify Part # D3209-1 corrected. line point sharpie, to correct from D3109-1	BB 05/07/13	<i>BB</i> 05/07/13	<i>BB</i> 05/07/13	<i>BB</i> 05/07/13

Part No: D3209-041 PAR #: _____ Fault Category: Engineering / Programming NCR: Yes No DQA: 1/3 Date: 05/07/14
 NOTE: Date & initial all entries QA: N/C Closed: KJ Date: 05/07/14

DART AEROSPACE LTD	Work Order:	23194
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	TSG	Audited by:	SD	Prototype Approval:	N/A
Date:	05/05/12	Date:	05/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	<i>[Signature]</i>

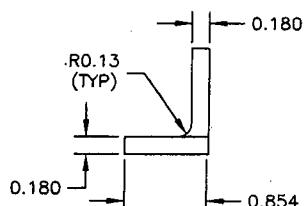
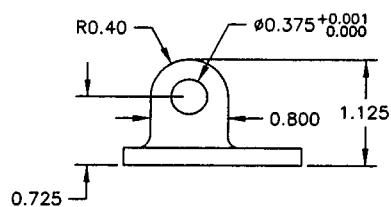
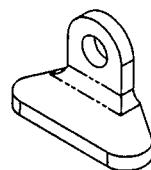
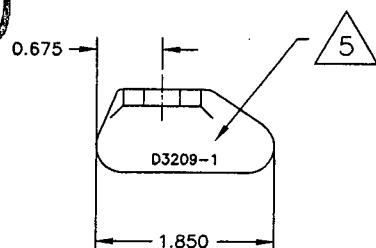
1995-02-27



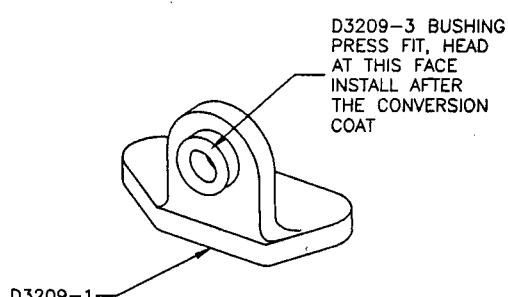
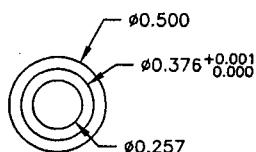
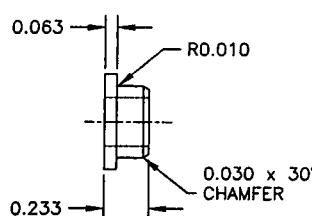
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.01.05



2 D3209-1 BRACKET



3 D3209-3 BUSHING
SCALE 1:2

4 D3209-041 ASSEMBLY

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23194

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

Job Costing Report

Dart Aerospace Ltd.
HawkesburyMay 06, 2005
09:55 am

Work Order No : 0023194
 Project Name : D3209-041
 Project For : WK522
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3209-041
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 05-05-05
 Est Finish Date : 05-31-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00